

Work Order ID 69886

Tuesday, May 24, 2011 10:03:07 AM



Page 1

Item ID: D2739

Accept



Setup Start



Revision ID:

SD 11-6-13

Stop



Item Name: 350 I Beam

Start Date: 5/24/2011

Start Qty: ~~8.00~~ *12.00*



Cust Item ID:

Required Date: 5/31/2011

Req'd Qty: ~~8.00~~ *12.00*



Customer:

Reference:

Approvals:

Process Plan: *P*

Date: *11-05-24*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2739	Rev E

100	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
	1-Cut D2600-5 to length as per Dwg D2739.								
	2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739								
	3-Use uni-bit to open holes to finish size as per Dwg D2739.								
	4-Bevel Fwd end of extrusion and Deburr holes and ends.								
	5-Deburr								

x12

DL

11/06/13

120	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish								
Hand Finishing	Memo	0.00							

x12

DL

11/06/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 69886

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Page 2

Item ID: D2739

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 I Beam

Start Date: 5/24/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

DP

11-6-13

(12)

140

Identify as per dwg & Stock Location: 46

0.00



Packaging

Memo

0.00

Packaging

x12

11/06/13

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/14

MF 11-06-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 10:03:13 AM

Page 1

Work Order ID: 69886

Parent Item: D2739

Parent Item Name: 350 I Beam



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev: C 02.11.28 Reformat KJ
 IPP Rev: D 06-03-21 As Per Rev C JLM
 IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev: F
 10.11.02 as per rev E DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-108

Manufactured

No

100

Each

174.0000

1

8



Extrusion 'I Beam' thin



Location

Loc Qty

Loc Code

HALL

90

47814

90

LG

84

47814

84

12

DL
 11/06/10

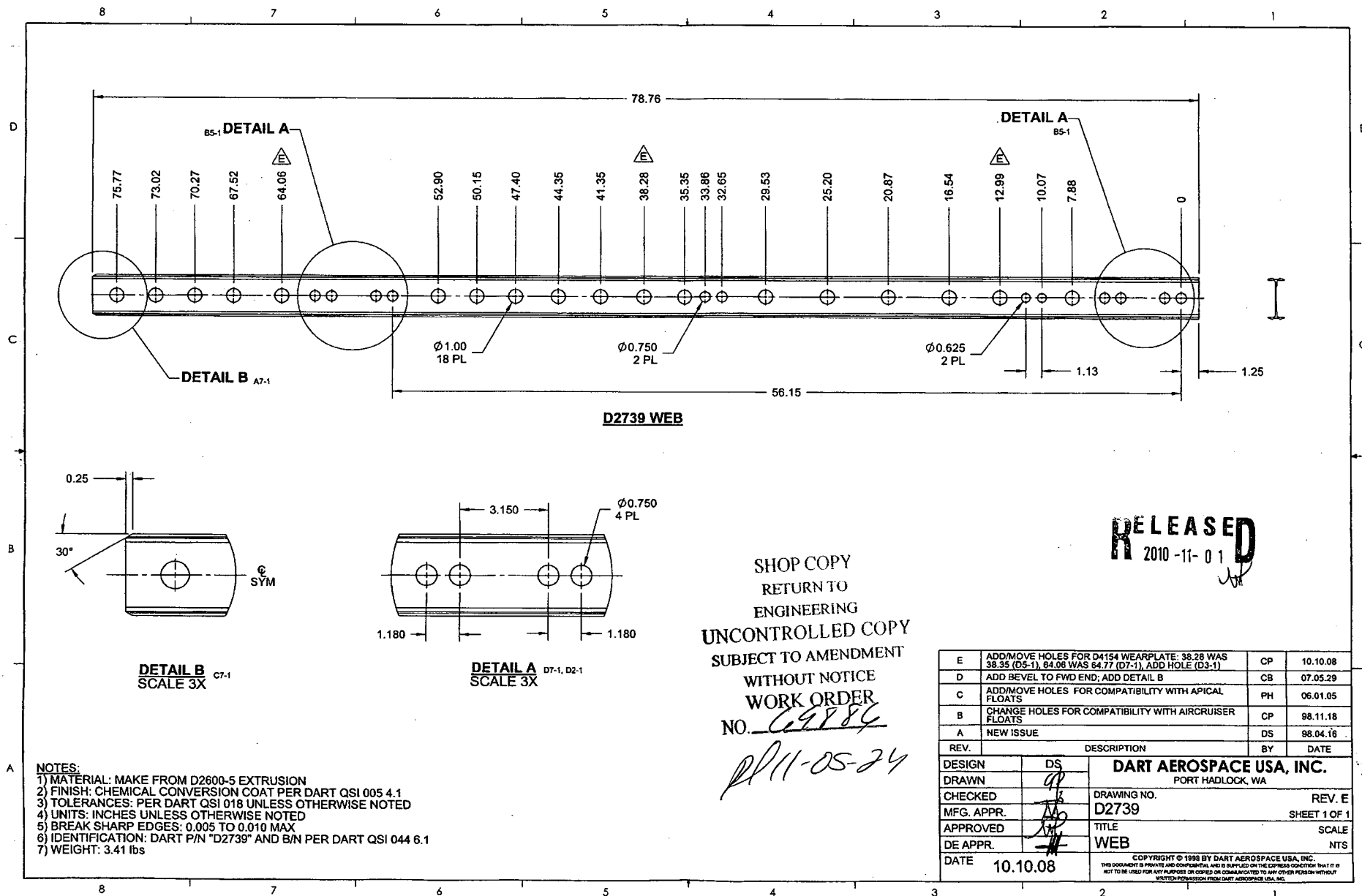
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



RELEASED
2010-11-01

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69884

2011-05-24

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (D5-1), 64.06 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE

DESIGN	DS	DART AEROSPACE USA, INC.	
DRAWN	g	PORT HADLOCK, WA	
CHECKED	g	DRAWING NO.	REV. E
MFG. APPR.	g	D2739	SHEET 1 OF 1
APPROVED	g	TITLE	SCALE
DE APPR.	g	WEB	NTS
DATE	10.10.08	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
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- NOTES:
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 3.41 lbs

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action . Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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